

Work Order ID 67817

Thursday, March 31, 2011 11:12:46 AM

Page 1

Item ID: D4322-3

Accept

Revision ID: PRELIM

Item Name: Spacer

Start Date: 3/31/2011 Start Qty: 20.00

Required Date: 4/4/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Approvals:

Process Plan: MF

Date: 11-03-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4322

PA1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg and Folio FB039

2-Break all sharp edges 0.010 max.

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20

20

20

11/4/4

11/4/4

11-04-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67817

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Page 2

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Item Name: Spacer

Start Date: 3/31/2011 Start Qty: 20.00

Required Date: 4/4/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20. BL 11-4-4

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 6 11-4-4

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PO2390
Ship
EagleCMF
11-03-04

W/O:		WORK ORDER CHANGES						
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Work Order ID 67817

Thursday, March 31, 2011 11:12:46 AM

Page 3

Item ID: D4322-3

Accept

Revision ID: PRELIM

Item Name: Spacer

Setup Start

Stop

Start Date: 3/31/2011 Start Qty: 20.00

Required Date: 4/4/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*ship
style***POSITIVE RECALL**EFFECTIVE 11033 / AUTH ll

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 11:12:42 AM

Page 1

Work Order ID: 67817



Parent Item: D4322-3



Parent Item Name: Spacer

Start Date: 3/31/2011

Required Date: 4/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 11-02-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R1.000

Purchased

No

f

19.4160

1.454737



ROUND BAR#100"

SD 11/4/4

Location

Loc Qty

Loc Code

MAT013

19.416

116406

19.416

~~1.6~~ ~~21~~

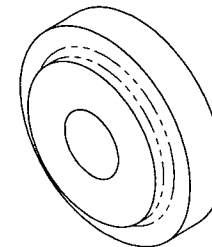
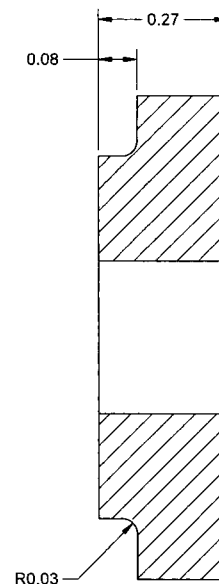
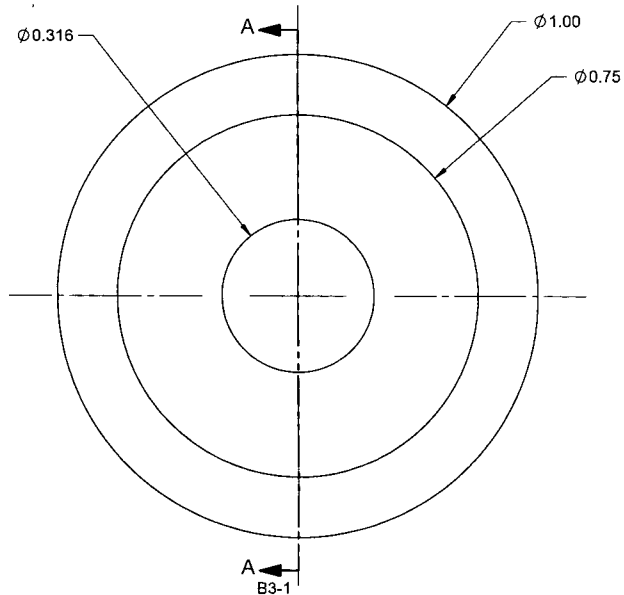
W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries



#67817

SECTION A-A
SCALE 4X B6-1

D4322-1 SPACER

PRELIMINARY ISSUE

11.01.13

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
REF DART SPEC M6061T6R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

PA2	NEW ISSUE		11.01.13
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4322 TITLE SPACER COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. PA
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APPROVED	N/A		SCALE
DE APPR.	N/A		NTS
DATE	11.01.13		

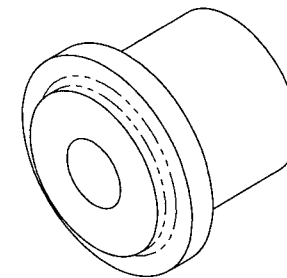
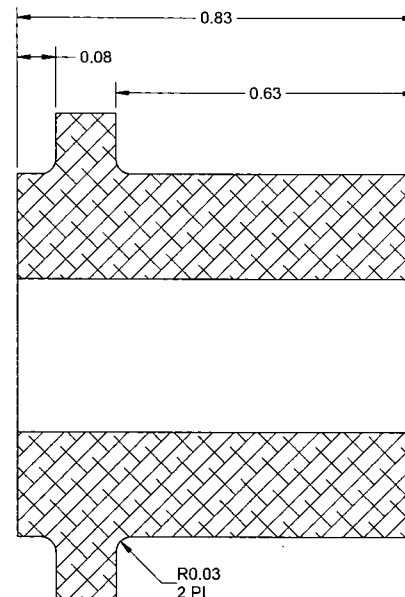
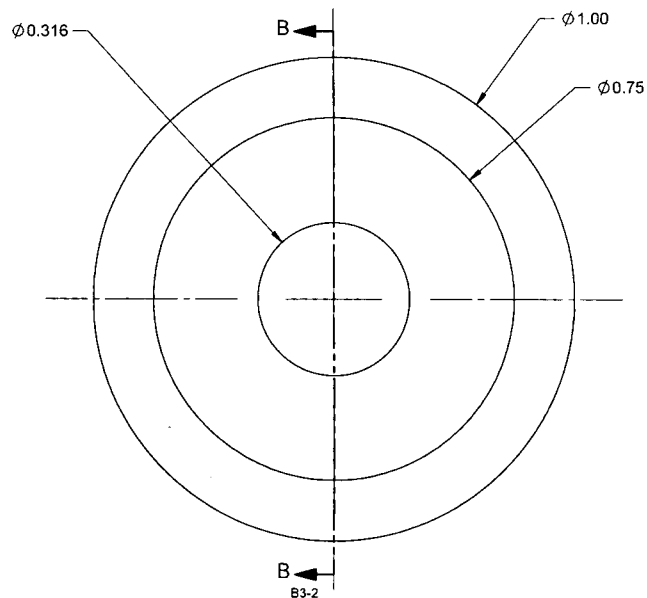
W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4322-3 SPACER

SECTION B-B
SCALE 4X B6-2

#67817

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
REF DART SPEC M6061T6R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

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